

Work Order ID 66399

Monday, February 14, 2011 10:56:08 AM

Page 1

Item ID: D2938-1

Revision ID:

Item Name: Saddle LH Out, 206

Start Date: 2/15/2011 Start Qty: 4.00

Required Date: 2/28/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: *mf*

Date: *11-02-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 66399

Monday, February 14, 2011 10:56:09 AM



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Item ID: D2938-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH Out, 206

Start Date: 2/15/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

RT 11-03-09

170

Identify as per dwg & Stock Location: 421

0.00



Packaging

Memo

0.00

Packaging

11/3/9 sf (40)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/9 JF

CL 11/03/09

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Picklist Print

Monday, February 14, 2011 10:56:05 AM

Page 1

Work Order ID: 66399



Parent Item: D2938-1



Parent Item Name: Saddle LH Out, 206

Start Date: 2/15/2011

Required Date: 2/28/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003 		Manufactured	No			100	Each	30.0000	1	4			
Saddle Billet, 7075													

Handwritten signature and date 11-3-2

Location

Loc Qty

Loc Code

MAT

20

65151

20

MAT042

10

65175

10

Handwritten circled 4

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NOTES:

- | | | |
|----------|----------------|---|
| C | 06.11.09 | R0.188 WAS R0.30 TO R0.25 |
| B | 00.05.29 | CHANGED GEOMETRY AND MATERIAL |
| A | 99.11.12 | NEW ISSUE |
| DESIGN | DRAWN BY |  DART AEROSPACE USA, INC.
BELLEVUE, WA |
| CHECKED | APPROVED | |
| DATE | TITLE | REV. C |
| 06.11.09 | SADDLE OUTSIDE | SHEET 1 OF 1 |

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DART AEROSPACE USA, INC.

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DART AEROSPACE LTD	Work Order: 66399
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.131	.129	.132	.132		
B	0.100	0.140		.132	.131	.128	.128		
C	0.100	0.140		.140	.135	.135	.134		
D	0.210	0.230		.223	.222	.222	.222		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.257	.257	.257	.257		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.115	.113	.113	.113		
O	0.540	0.560		.551	.552	.552	.552		
P	0.490	0.510		.498	.498	.498	.498		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.255	.253	.253	.253		
T	0.100	0.180		.127	.127	.127	.127		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.258	1.261	1.260	1.260		
Y	1.565	1.585		1.574	1.576	1.572	1.572		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 11-3-2	Date: 11/03/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

RQ.02

RQ.06
RQ.02

RQ.09
RQ.09

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